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5T 525

Gloss Finish

D4091-1
Job Sheet 203513



Part No: D4091-1

Job Qty: 2 pcs

Part Name: Mounting Lug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/20/19

Job Tracking No:

Due Date: 12/5/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: Dwg D4091 Rev. A IPP REV :A NEW ISSUE 10-03-31 JLM VERIFIED BY:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
150	Rework - 1 - Startup	2 pcs	12/5/19	12/5/19	0.00	0.20	Powdercoat - 1		
							Powdercoat - 2		BEB 19-11-29
							Powdercoat - 3		
							Powdercoat - 4		BR 14 12-6
160	Rework - 2 - B4B	2 pcs	12/5/19	12/5/19	0.00	0.00	QC 3 - 10		
							QC 3 - 13		
							QC 3 - 15		
							QC 3 - 17		
							QC 3 - 18		
							QC 3 - 2		
							QC 3 - 28		
							QC 3 - 3		
							QC 3 - 30		
							QC 3 - 34		
							QC 3 - 36		
							QC 3 - 41		
							QC 3 - 51		
							QC 3 - 58		
							QC 3 - 59		
							QC 3 - 68		
							QC 3 - 9		
							QC 3 - 40		603 DEC 10 2019
							QC 3 - 19		
							QC 3 - 43		
170	Packaging 3-1 - Stock - B4B	2 pcs	12/5/19	12/5/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		

DAS
81
9-89

				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	DAS
				Packaging 3 - 35 - B4B	21
				Packaging 3 - 36 - B4B	DEC 12 2019
180 QC 21 - SA	2 pcs	12/5/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DEC 12 2019
				QC 21 - SA - 53	

Part Op 150 - Scuff and re powder coat Powder coat white gloss as per QSI005 4.3.5 START TIME: _____ OVEN
 Descriptions: TEMPERATURE: _____ FINISH TIME: _____
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

M.4.013205

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4091-1	Mounting Lug	2 pcs (1 ea)	150-Rework - 1 - Startup	5219898

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
150-Rework - 1 - Startup	D4091-1	2	66	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Mounting Lug	1.380Inches $\pm$ 0.030	1.410 1.350		
2	Mounting Lug	4.450Inches $\pm$ 0.030	4.480 4.420		
3	Mounting Lug	0.270Inches $\pm$ 0.030	0.300 0.240	Reference	
4	Mounting Lug	1.910Inches $\pm$ 0.030	1.940 1.880		
5	Mounting Lug	0.690Inches $\pm$ 0.030	0.720 0.660		
6	Mounting Lug	0.293Inches $\pm$ 0.010	0.303 0.283		
7	Mounting Lug	0.735Inches $\pm$ 0.010	0.745 0.725	Reference	
8	Mounting Lug	0.375Inches $\pm$ 0.010	0.385 0.365		
9	Mounting Lug	3.700Inches $\pm$ 0.010	3.710 3.690		
10	Mounting Lug	0.625Inches $\pm$ 0.010	0.635 0.615		
11	Mounting Lug	0.375Inches $\pm$ 0.010	0.385 0.365		
12	Mounting Lug	0.257Inches $\begin{matrix} + 0.006 \\ - 0.001 \end{matrix}$	0.263 0.256	Diameter	
13	Mounting Lug	0.400Inches $\pm$ 0.030	0.430 0.370	Radius	
14	Mounting Lug	2.310Inches $\pm$ 0.010	2.320 2.300	Reference	

Plex 11/20/19 2:44 PM dart.lacelle.linda

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Container No: S236189



Part: D4091-1

Job No: 203513

Serial No/Batch: S236189

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/29/19